Qty:

4 Um:

Each

Date: User: Thursday, 5/10/2007 2:23:43 PM

Kim Johnston

Process Sheet

Drawing Name

Part Number

Material **Due Date**

Drawing Number

Project Number

Drawing Revision

: GASKET

: D353613

: 5/17/2007

: N/A

D3536 REV A

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 32270

Estimate Number

: 12723

P.O. Number

This Issue Prsht Rev.

S.O. No. : 1/1/

: SMALL /MED FAB

Checked & Approved By

Comment

First Issue

Written By

Previous Run

: Est Rev:

New Issue 07-02-14 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

MNEO60S063

NEOPRENE SHEET 0.063

Comment: Qty.:

0.8682 sf(s)/Unit Total:

3.4730 sf(s)

NEOPRENE SHEET 0.063

Batch:

M103 104

Sab

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3536

Dwg Rev:_ Prog Rev:_

07105/12

3.0

QC2

2-Deburr if necessary

INSPECT PARTS AS THEY COME OFF MACHINE





Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD



4.0

QC8

SECOND CHECK

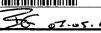




Comment: SECOND CHECK

PACKAGING 1

PACKAGING RESOURCE #1



5.0

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No:	PAR #: Fault Ca	ategory: NCR: Yes No DQA:	Date: 07/05/14
		QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
			Description of NC		Corrective Action Section B			Approval	Approval
DATE	STEP	r	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Chief Eng	Approva QC Inspecto
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NOTE: Date & initial all entries

Date:

Thursday, 5/10/2007 2:23:43 PM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 32270

Part Number: D353613

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE





Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
-							
		÷					
Part No	:	PAR #: Fault Category: N	CR: Yes	s No DQ	۸:	Date:	

QA: N/C Closed: ____ Date: ____

NCR: WORK ORDER NON-CONFORMANCE (NCF							ORK ORDER NON-CONFORMANCE (NCR)					
		Description of NC		Corrective Action Section B			Annewal					
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector				
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NOTE: Date & initial all entries

26.65 23.15 21.15 13.40 0.90 - 5.65 1.89 3.90 DETAIL A #0.19 (TYP 3 PLS)

D3536-11 GASKET

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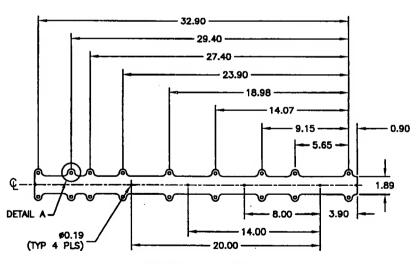
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- 2) FINISH: NONE
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- 5) ALL DIMENSIONS ARE IN INCHES
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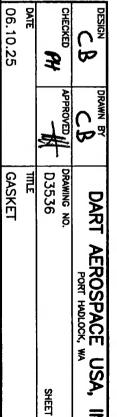


D3536-13 GASKET

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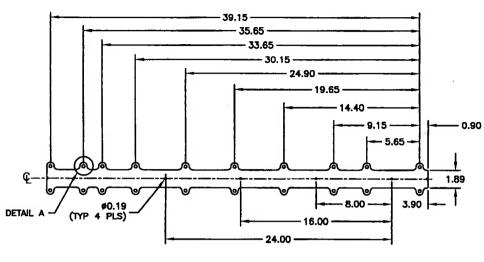
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D3536-15 GASKET

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32.70 21.80 16.35 0.90 DETAIL A 1.89 2.00 - 6.00 8.00 #0.19 (TYP 4 PLS) 16.00 24.00 D3536-21 GASKET

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DATE 06.10.25 CHECKED B Œ (Co g DRAWING NO. GASKET DART **AEROSPACE** USA,

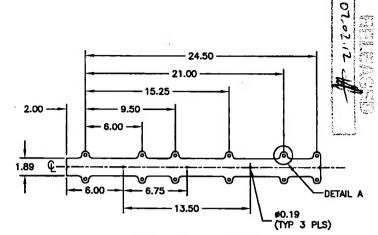
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22.50 19.00 2.00 -9.50 6.00 1.89 DETAIL A 6.00 **≠**0.19 (TYP 3 PLS)

D3536-31 GASKET



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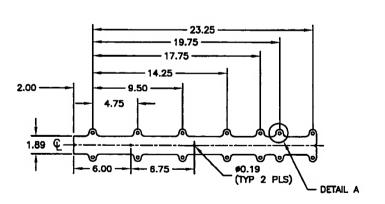
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D3536-35 GASKET

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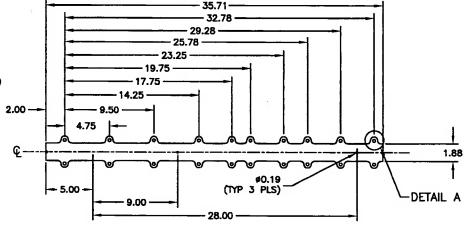
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2) FINISH: NONE

3) PART IS SYMMETRICAL ABOUT ©
4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES
6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
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D3536-39 GASKET

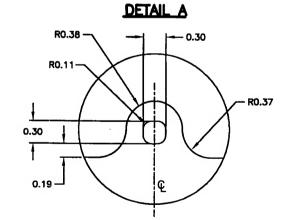
27.98 25.08 18.50 15.00 2.00 -3.43 1.88 4.00 #0.19 (TYP 2 PLS) 3.90 DETAIL

D3536-41 GASKET

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

- 2) FINISH: NONE 3) PART IS SYMM 4) TOLERANCES A
- PART IS SYMMETRICAL ABOUT &
 TOLERANCES ARE PER DART QSI 018 UNLESS
 OTHERWISE NOTED
 ALL DIMENSIONS ARE IN INCHES
 IDENTIFY WITH DART P/N USING A WHITE FINE POINT
 PERMANENT INK MARKER





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PA PA	*	D3536	SHEET 6 OF 6
DATE		JIIII 37UII	SCALE
06.10.25		GASKET	1:10

DART AEROSPACE LTD	Work Order:	32270
Description: Bearpow GASKET	Part Number:	D353613
Inspection Dwg: D3536 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

	spection Sheet wing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Α	32.90	+/-0.030	32.90	_		M-t	
В	29.46	+20.030	29.90	/		H-T	
С	27.40	4-0.030	27.40			M-T	
D	23.90	4-0.030	23.90			M-+	
E	18.98	Y. 0. 030	19.98	V		M-T	
F	14.07	4.0.030	14.07	/		4-7	
G	9.15	+/= 0.030	9.14	V		Ven	
Н	5.65	4-0.030	5,64			Um.	
<u> </u>	0.90	T- 0.030	0.89	/		Vernsheist	H sauge
J	1,89	1/0.030	1.89			Vern	•
K	3,40	+/-0,030	3.90	/		Vern	
L	8,00	4/.0.030	7.98			Vern	
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Measured by: SAD	Audited by:	Prototype Approval:	N/A
Date: 07/05//2	Date: 67.05.12	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.01.09	New Issue	KJ/RF	